

Date: Tuesday, 12/5/2006 8:19:23 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: JACK SADDLE
<b>Job Number</b>	: 29808		
<b>Estimate Number</b>	: 11177		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D2281
<b>This Issue</b>	: 12/5/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2281 REV G
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 27897	<b>Drawing Revision</b>	: G
	<b>Type</b> : SMALL / MED FAB	<b>Material</b>	: N/A
<b>Written By</b>	: <u>[Signature]</u>	<b>Due Date</b>	: 12/23/2006
<b>Checked &amp; Approved By</b>	: <u>[Signature]</u> 061205	<b>Qty:</b>	100
<b>Comment</b>	: Est Rev A Removed from 9 Digit 05-12-02 JLM	<b>Um:</b>	Each
	Est: rev B 06.07.17 waterjet EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S14GA	304SS .080
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**Comment:** Qty.: 0.1313 sf(s)/Unit Total: 13.1250 sf(s)

304SS .080

batch: m101873 ml a 12 07

(100)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2281

Dwg Rev: G

Prog Rev: G

ml a 06 12 05

(100)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml a 06 12 10

(100)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

Doc 6/12/11 (100)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** Deburr

SAD 06:12:18 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:19:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 29808

Part Number: D2281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB

06/12/19

(100)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/20

100

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W523

06.12.20

(100)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/22

(100)

Job Completion



06.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>29808</b>
<b>Description:</b> Jack Saddle		<b>Part Number:</b>	<b>D2281</b>
<b>Inspection Dwg:</b> D2281 <b>Rev:</b> G		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.475	✓		vern	
4.114	+/-0.010	4.114	✓		vern	
2.933	+/-0.010	2.936	✓		vern	
1.535	+/-0.010	1.587	✓		vern	
0.354	+/-0.010	0.355	✓		vern	
0.354	+/-0.010	0.355	✓		vern	
0.604	+/-0.010	0.605	✓		vern	
2.000	+/-0.010	2.002	✓		vern	
3.396	+/-0.010	3.396	✓		vern	
3.646	+/-0.010	3.648	✓		vern	
4.000	+/-0.010	4.005	✓		vern	
1.525	+/-0.010	1.525	✓		vern	
2.475	+/-0.010	2.471	✓		vern	
Ø0.323	+0.006/-0.001	0.325	✓		vern	
0.080	+/-0.010	0.75	✓		vern	

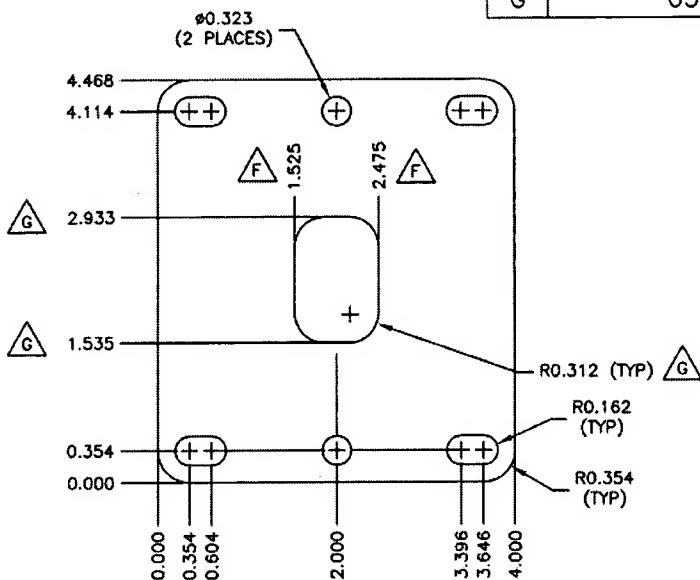
<b>Measured by:</b>	<i>MM</i>	<b>Audited by:</b>	<i>DD</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<i>06/12/11</i>	<b>Date:</b>	<i>06/12/11</i>	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>

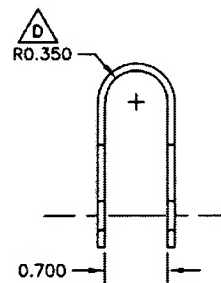
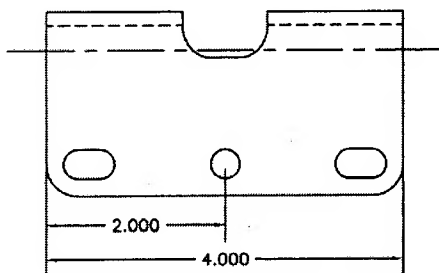


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

RELEASED  
*[Signature]*  
05/08/11



FLAT LAYOUT



**D2281 JACK SADDLE**

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. **29808**

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